Work Order ID 5969	Vork (	Order	ID	59699
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Wednesday, June 09, 2010 2:31:32 PM



Page 1

Item ID:

D4000-5

Accept

Setup Start

Stop



**Revision ID:** 

**Item Name:** 

Fuel Tank Vent Fitting

**Start Date:** 

6/9/2010

Start Qty: 2.00

Required Date: 6/17/2010 Req'd Qty: 2.00

Date:

**Cust Item ID: Customer:** 

Reference:

Approva	ls:
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Process Plan:

Α

Date: \_\_\_\_

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop

Sequence ID/ Work Center ID

**Draw Nbr** 

Operation Description

**Revision Nbr** 

Set Up/ **Run Hours**  **Tool ID** 

Tool # Plan Code

Accept Qty

Reject **Qty** 

Reject Insp. Number Stamp

D4000 100

Doosan Doosan Lathe

Memo

Turn as per DWG and Folio Fa906

Folio Rev: N/A Dwg Rev: A

0.00

0.00

. SL 10/06/22

Tap using DT9586 BLOCK

Deburr

QC2- Inspect parts off machine FAI/FAIB

110

OC

0.00

SL 10/06/22

Memo

0.00

Quality Control

Dart Aerospa	ace Ltd	l
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W/O:			WC	ORK ORDER CHANG	iES					
DATE	STEP	PROCEDURE CHANGE By					Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	):	PAR #:	Fault Cate	gory:	 _ NCR: Y	es N	o <b>DQ</b> /	⊥ A:	Date:	
		esolution:								
NCR:				ER NON-CONFORMA						
DATE STED		Description of NC		ion B	Verification Approval		Approval	Approval		
	DATE STEP	Section A	Initial Chief Eng	Action Description Chief Eng	1 -	n & ate	Secti		Chief Eng	QC Inspector
		·								

#### Work Order ID 59699

Wednesday, June 09, 2010 2:31:32 PM



Page 2

Item ID:

D4000-5

Accept

Setup Start

Stop



Revision ID:

Item Name: Fuel Tank Vent Fitting

Start Date:

**Required Date: 6/17/2010** 

6/9/2010

Start Oty: 2.00

**Req'd Oty: 2.00** 

**Cust Item ID: Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Run

Start



Date:

SPC (Y/N):

Date:

Tool ID

Date:

Stop



Sequence ID/

Work Center ID

120

Quality Control

Operation Description

QC8- Inspect parts - second check

Set Up/ **Run Hours** 

Tool # Plan Code

Reject Accept Oty

Reject Number Stamp

Insp.

Memo

Memo

0.00

J. 8 10/06/22

Oty

130

Packaging

Packaging

Identify as per dwg & Stock Location:

QC21- Final Inspection - Work Order Release



0.00

140

0.00

0.00

N 10-8-30

Quality Control

Memo

Dart Aerospace L	.ta
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W/O:			WO	RK ORDER CHANG	GES					
DATE	STEP	PR	OCEDURE CHAI	NGE	В	/	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	jory:	NCR: Y	es N	lo <b>DQ</b>	<b>\</b> :	_ Date: _	
		olution:								
NCR:			WORK ORDE	R NON-CONFORM	ANCE (N	ICR)				•
DATE	STEP	Description of NC		Corrective Action Sec	ction B		Verific	ation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		gn & ate	Section C		Chief Eng	QC Inspector
				<u> </u>						
	-				-					

#### **Picklist Print**

-Wednesday, June 09, 2010 2:31:35 PM

Work Order ID: 59699

Parent Item:

D4000-5

Parent Item Name:

Fuel Tank Vent Fitting

Comments:

Ipp Rev:A New Issue 10-01-28 JLM Verified By:EC IPP rev B 10.05.13

ecn10-562 EC verified by:DD

**Start Date:** 6/9/2010

**Required Date: 6/17/2010** 

Page 1

Status

Start Qty: 2.00

Required Oty: 2.00

Component Item ID/

Item Name M6061T6R1.625 Replacement Mfg/ Item ID

Purch Purchased

Primary Bin Item Location No

Last Location

Route Seq ID 100

Unit of Qty on Measure Hand f 20.2080

Loc Code

Qty per Kit Total

0.051

Otv Issued 0.107368

Qty

Date Issued

6061T6 ROUND BAR 1.625

Location

MAT013

109920

Loc Qty

20.208

-13 SL 10/06/22

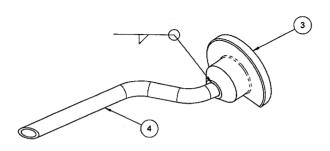
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W/O:			W	ORK ORDER CHA	NGES					
DATE	STEP	PRO	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	NCR	: Yes	No <b>DQ</b>	<b>A</b> :	_ Date: _	
	Re	esolution:	Dispositio	n:	QA:	N/C Cld	sed:		Date: _	
NCR:		V	WORK ORD	ER NON-CONFOR	RMANCE	(NCR	)	, , , , , , , , , , , , , , , , , , , ,		
DATE	STEP	Description of NC		Section B	Verific	Verification Approx		Approval		
DAIL	JILI	Section A	Initial Chief Eng	Action Descripti Chief Eng	on	Sign & Date	& Section C		Chief Eng	QC Inspector
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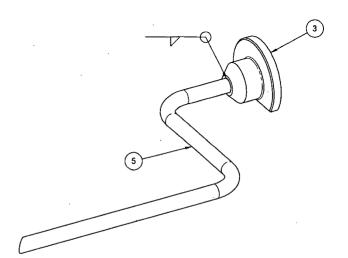
DART AEROSPACE LTD	Work Order: 59699
DART ALROSI AGE 213	
Description: Jue 1 tank went fitting	Part Number: NHO00 - S
Descriptions   Mar   Issue	Page 1 of 1
Inspection Dwg: \\ 4000 Rev: A	rage ioi

nspection Dwg	: <u>A 4000 Rev:</u>	Α				rage	. 1011	
	FIRST	ARTICLE IN	SPECTIO	ON CHE	CKLIST			
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Drawing	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Com	ments	
Dimension	4.008	581	/					
5.578		<del>                                     </del>		6				
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.02	2.030	1.015	1					
8-NPT		/						
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.98	+ .030	.979	/	ļ	-			
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	1	Audited by:	18		Prototype Ap	proval:	N/A	
Measured by: Date:		Date:	<del>  /3'/ /</del>	27		Date:	N/A	
	1.07001000		1-1-		Re	rised by	Approv	
Rev Date	Change New Issue			·	KJ/	JLM		

				. 6	5
ITEM	QTY. -043	QTY, -045	P/N	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	Х		D4000-041	DRAIN FITTING ASSEMBLY, AFT	JCA-M47-1-06
2	ļ	х	D4000-043	DRAIN FITTING ASSEMBLY, FWD	JCA-M47-1-15
- 3	<del></del>	1	D4000-3		
4	1	<u> </u>	D4000-3	FUEL SUMP DRAIN FITTING INTERNAL DRAIN LINE, AFT	
5		1	D4003-3	INTERNAL DRAIN LINE EMD	



D4000-041 DRAIN FITTING ASSEMBLY, AFT



2

D4000-043 DRAIN FITTING ASSEMBLY, FWD

3

D

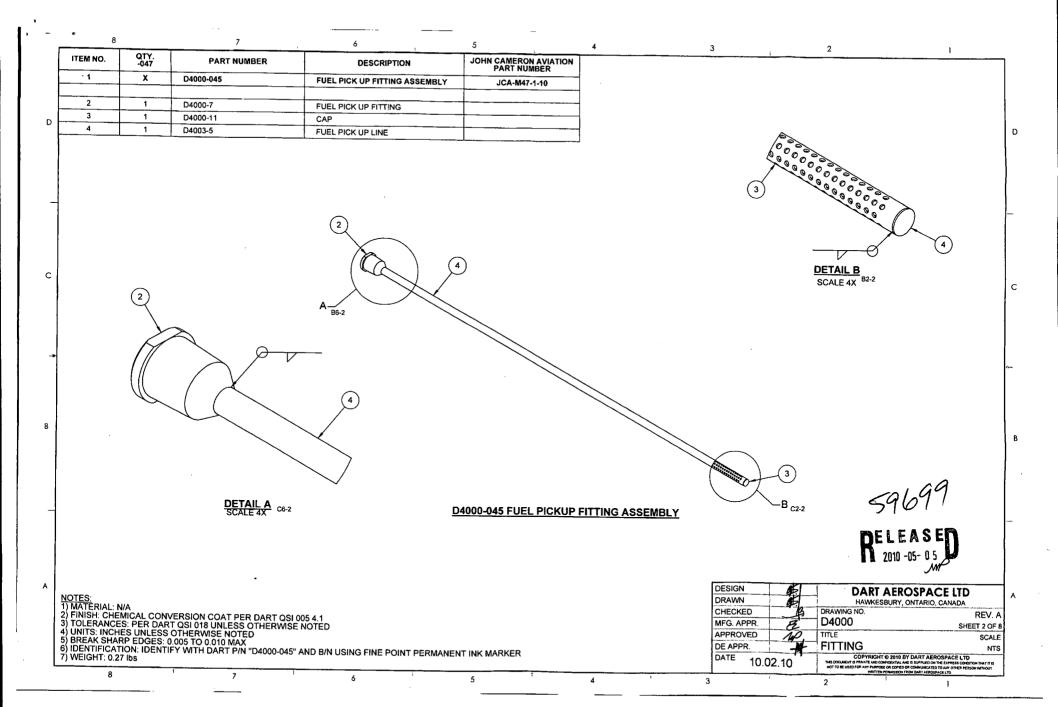
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Α	NEW ISS	SUE		45	10.02.10
REV.			DESCRIPTION	BY	DATE
DESIG!				ROSPACE L' Y, ONTARIO, CANAL	_
CHECK MFG. A		居	DRAWING NO. D4000		REV. A
APPRO		14	FITTING		SCALE
DATE	10.0	2.10	THIS DOCUMENT IS PRIVATE AND CONFIDENT! NOT TO BE USED FOR ANY PURPOSE OR CON	O BY DART AEROSPACE  LALAMDIS SUPPLED ON THE EXPRESS  PED OR COMMUNICATED TO ANY OTH  ION FROM DART AEROSPACE LTD.	CONDITION THAT IT IS

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4000-043/-045" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: D4000-043 - 0.04 lbs
D4000-045 - 0.05 lbs

Dart Aerospace Ltd	Dart	<b>Aeros</b>	pace	Ltd
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	part -											
W/O:			W	WORK ORDER CHANGES								
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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					NCR: Yes No DQA: Date:							
	Res	olution:	Dispositio	n:	_ QA: N/C CI	osed:		Date: _				
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCF	R)		7/ // //				
DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval			
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section		Chief Eng	QC Inspector			
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DATE	STEP	Description of NC	Corrective Action Section			Verification		Approval	Approval		
	Section A	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	k Secti	on C	Chief Eng	QC Inspector		
								11/100 600			

5 DART AEROSPACE PART NUMBER JOHN CAMERON AVIATION PART NUMBER D4000-1 JCA-M47-1-04 D D Ø1.97 0.28 R0.02 DRILL Ø0.921 THRU-С 3/4 NPT TAP FROM-THIS SIDE Ø1.57 В SECTION C-C B3-3 **D4000-1 FUEL SUPPLY FITTING** NOTES: 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) REF DART SPEC M6061T6R DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. 2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.12 lbs REV. A D4000 MFG. APPR SHEET 3 OF 8 APPROVED TITLE SCALE DE APPR. FITTING NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD has dodument a renut and completing, and is supplied to the especial control not to be used for any hydrospic of compact of compact and any official religion written retrieved from any farthospic. DATE 10.02.10 8 7

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W/O:			W	ORK ORDER CHANG	ES	W						
DATE	STEP	PR	PROCEDURE CHANGE			Date C	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
Part No: PA		PAR #:	Fault Cate	gory:	_ NCR: Yes	NCR: Yes No DQA: Date:						
Resolution:												
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DATE	STEP	Description of NC		on B	Verification	on Approval	Approval					
	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section C		QC Inspector				
								-				

6 5 4 3 2 DART AEROSPACE PART NUMBER JOHN CAMERON AVIATION PART NUMBER D4000-3 JCA-M47-1-05 D CHAMFER 0.020 X 45° 0.16 -R0.69 С R0.02 1/8 NPT-1.06  $\phi$ 0.26 $^{+0.01}_{-0.00}$ Ø0.34 0.71 D--CHAMFER 0.18 X 45° B3-4 - 0.66 SECTION D-D **D4000-3 FUEL SUMP DRAIN FITTING** NOTES: 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS4160) REF DART SPEC M6061T6R DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA 2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.03 lbs DRAWING NO. CHECKED REV. A D4000 MFG. APPR. SHEET 4 OF 8 APPROVED TITLE SCALE **FITTING** DE APPR. NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD

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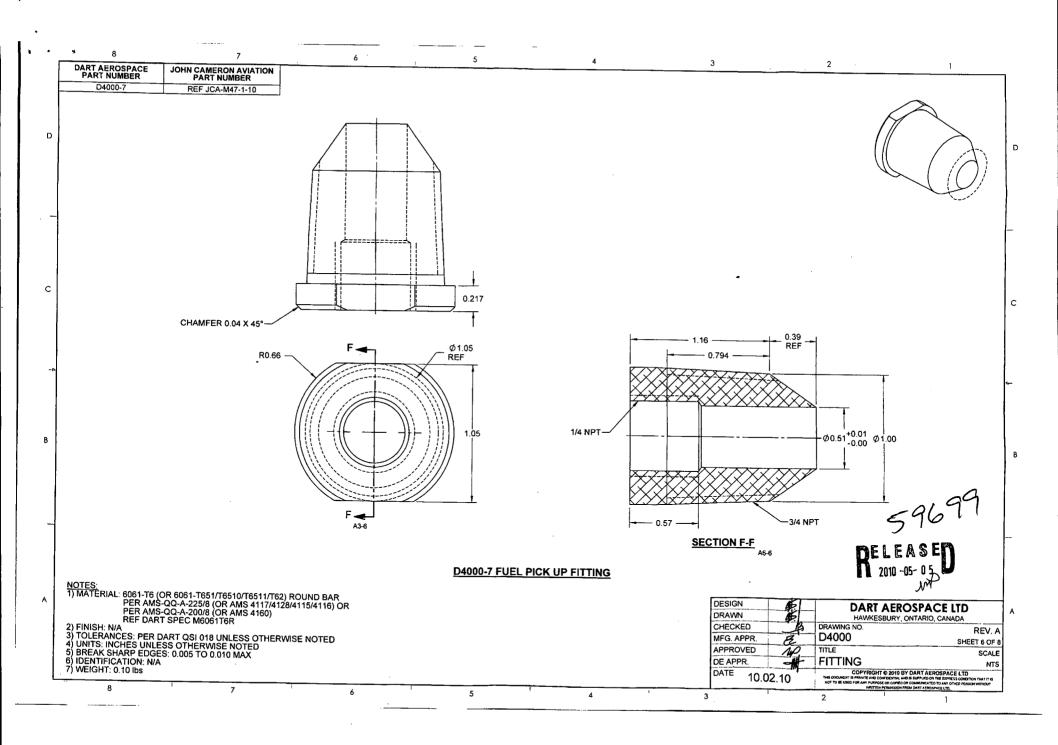
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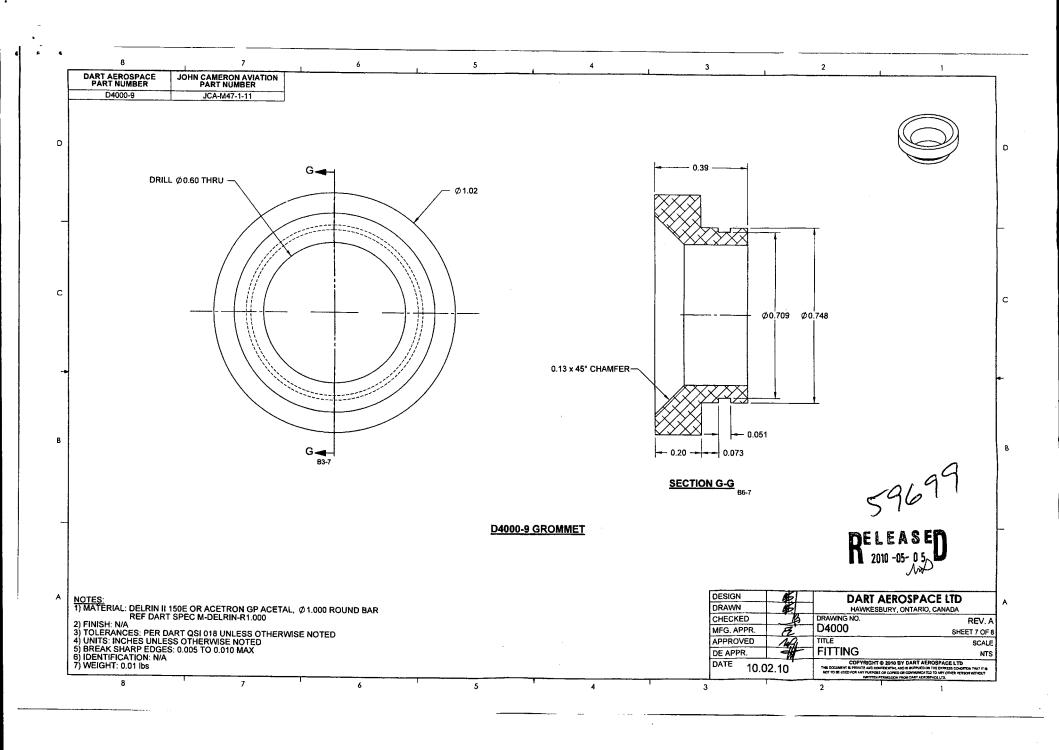
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DATE	STEP	Description of NC			tion B	Verification	Approval	Approval			
	OIL!	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector			
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6 5 3 2 DART AEROSPACE PART NUMBER JOHN CAMERON AVIATION PART NUMBER D4000-5 JCA-M47-1-09 D Ø 1.57 - 0.59 R0.02 DRILL Ø0.578 THRU-3/8 NPT TAP FROM -THIS SIDE 0.98 0.12 ---SECTION E-E B6-5 B3-5 **D4000-5 FUEL TANK VENT FITTING** NOTES: 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) REF DART SPEC M6061T6R DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN 2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.04 lbs CHECKED DRAWING NO. REV. A D4000 MFG. APPR. SHEET 5 OF 8 APPROVED TITLE SCALE **FITTING** DE APPR. NTS DATE 10.02.10 COPYRIGHT © 2010 BY DART A EROSPACE LTD
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		Section A	Initial Chief Eng	Action Description Chief Eng		Date	Section	on C	Chief Eng	QC Inspector			
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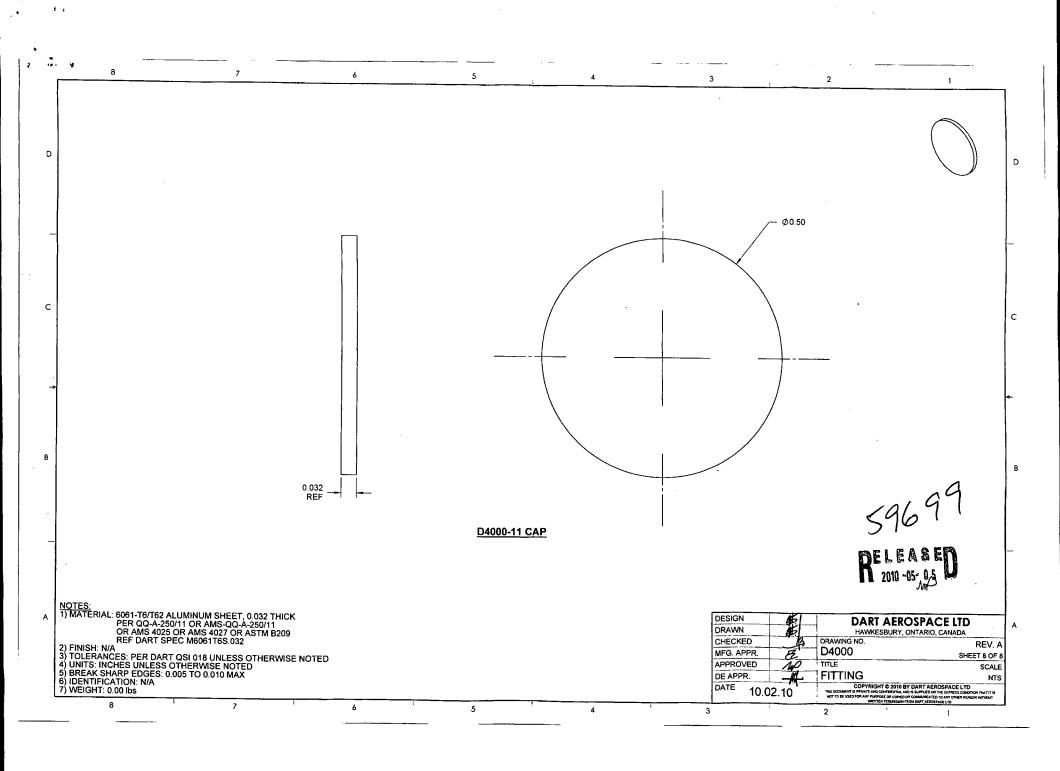


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DATE	STEP	Description of NC	Corrective Action Section B			Verification			Approval	Approval					
		Section A	Initial Chief Eng	Action Description Chief Eng		n & ate	Section		Chief Eng	QC Inspector					



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